

Client	Babyone - remmidemmi GmbH	QIMA Service No	R-Cloud-22223825
Supplier	Huian Guanqun Light Industry Co., Ltd.	Auditor	Sam Yang
Factory	Huian Guanqun Light Industry Co., Ltd.	Date	03-Nov-2022
Industry	Textile, Apparel, Footwear & Accessories	Country	China

Factory Overall Score **8.5** of a possible 10

Audit Rating **Green** Approved

		Section Score	Theoretical Max	Score /10	Weight	Weighted Score
Ratings	Quality Management System	43	48	9.0	1	9.0
	Resources Management	29	39	7.4	3	22.3
	Stock Management	46	51	9.0	2	18.0
	Incoming Material Inspection	18	24	7.5	4	30.0
	Production Process	45	48	9.4	4	37.5
	Packing and Quality Control before Shipment	24	24	10.0	3	30.0
	Measurement, Analysis and Improvement	17	30	5.7	1	5.7
	Total				18	152.5

Valid until: 02-Nov-2023



Description of audited plant

1. The audited company name is Huian Guanqun Light Industry Co., Ltd.
2. The factory is located at New Street, Wangchuan Town, Huian County, Quanzhou City, Fujian Province, China.
3. The main products manufactured in the factory were Bag products etc., and the main production processes conducted in the factory were: Die-cutting, Sewing, Metal detection if required, Assembling & Packing.

Important remarks

1. No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained.
2. "Critical" components were not identified, and there was no method to define "Key" suppliers in place.
3. There was no system defined to ensure that any change in suppliers/materials was communicated efficiently to customer.
4. There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure.
5. Around 10% of different color inventory fabric materials was stored together without any proper segregation; All the pearl wool in the warehouse was put on the ground.
6. 10% semi-finished products in cutting workshop were put against the wall; Around 20% of semi-finished products in the sewing workshop were put against the wall & windows ; The semi-finished products in the peeling station were put on the ground directly.
8. Drinking cups were found in the production workshop.
9. Relevant qualifications for internal auditor was not available.
10. There were no Statistical Process Control charts existing for all critical characteristics.
11. The factory did not provide statistical analysis records of Process Capability.
12. The factory did not use Advanced Statistics to analyze data and define improvements.

Home Workers and Subcontractors

Is there any home workers used by factory? **No**
No home workers were used by factory.

Is there any subcontractor used by factory? **No**
No process was sub-contracted.

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Number of days spent: 1 MD



Auditor 1: Sam Yang

Supervisor: Henry Zhu

Departure time from home / office

Arrival time at Factory

Departure time from Factory

8:00 AM

9:30 AM

16:30 PM



Factory main gate



Factory name board



House number



Office building



Production building



Production building



GPS



Map



Sample room



The product to client



Fabric material storage



Packing materials storage



Die-cutting workshop



Sewing workshop



Metal detection if required



Packing workshop



Finished products storage



Business license



Worker on site



Worker on site



Worker on site



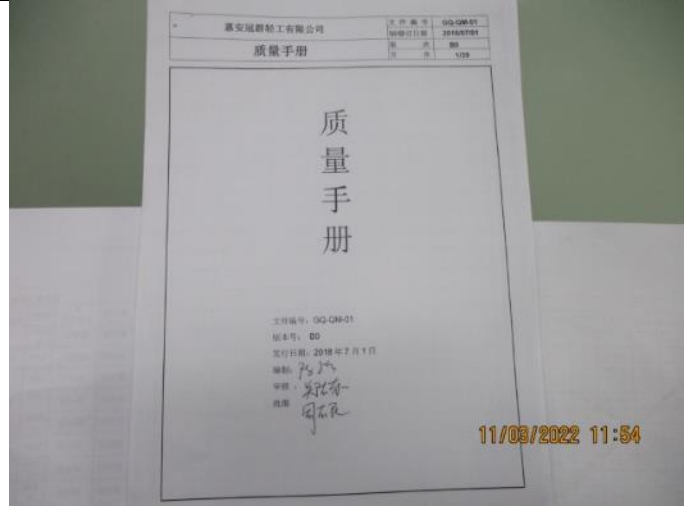
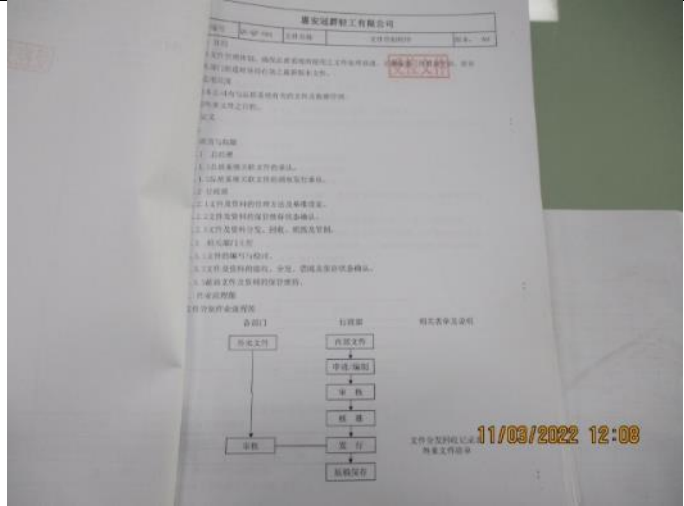
Worker on site

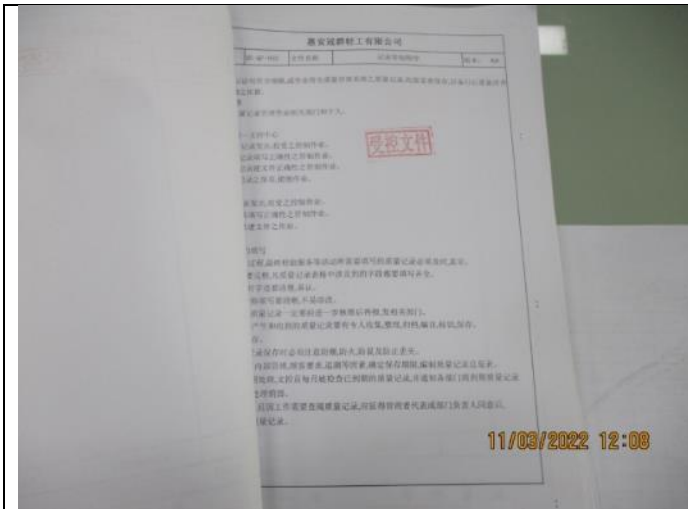
Part 1 Basic Factory Profile

Item		Finding	Comments	
1	Date of formation	06-Aug-2010	Nil.	
2	Legal status	Limited company	Nil.	
3	Location	New Street, Wangchuan Town, Huian County, Quanzhou City, Fujian Province, China.	Nil.	
4	GPS Location	25.079433 N, 118.821301 E	Nil.	
5	Area (m2)	15,896 m2	Nil.	
6	Owner	Ms. Wu Qingxia	Nil.	
7	Total staff in the factory	208	Nil.	
8	Total office staff	22	Nil.	
9	Total Management staff	3	Nil.	
10	Number of workers	183	Nil.	
11	Factory Manager	Ms. Zhuang Xiangli	Nil.	
12	Production Manager	Mr. Zheng Zhidong	Nil.	
13	Quality Manager	Mr. Zheng Junhua	Nil.	
14	Main markets	Europe & America	Nil.	
15	Annual turnover	CNY: 50,000,000	Nil.	
16	Business license	Date of issue: 06-Aug-2010	91350521559575710E	
		Expiry date: 05-Aug-2060		
17	Factory Description	Workshop/Warehouse	Description	Size
		Cutting workshop	2 lines	1,000 m2
		Sewing workshop	10 lines	3,400 m2
		Assembling & Packing workshop	4 lines	4,500 m2
18	Products	Products	Quantity	Main clients/destination countries
		Bag products	130,000pcs/month	Europe & America

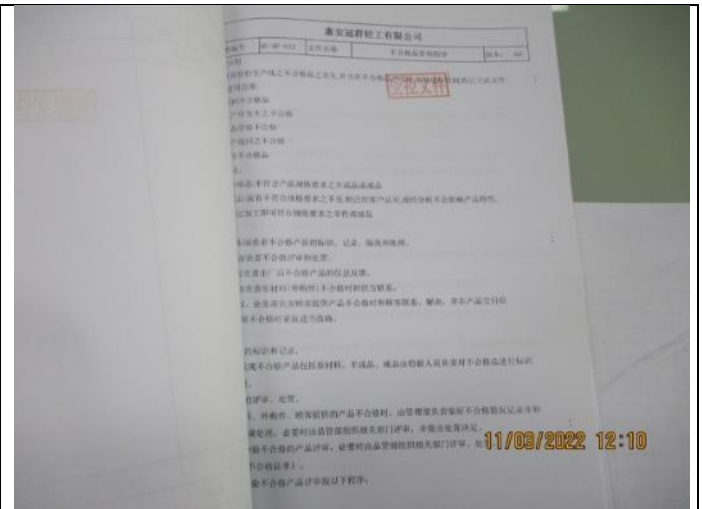
Part 2

Quality Management System

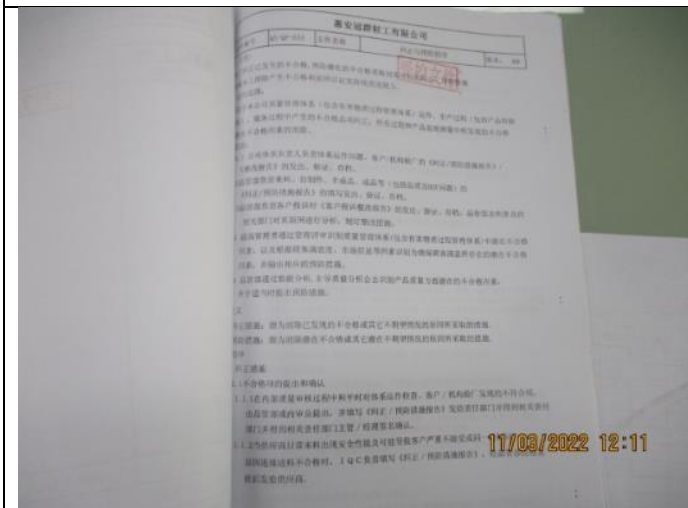
Quality Manual				
Questions		Findings/Comments	Score	
2.1	Does the factory have a quality manual, covering all the elements in current version of ISO9001?	1. Quality manual, document and record control procedure, internal audit control procedure, nonconforming product control procedure, corrective and preventive action control procedure etc. were established. 2. The factory did not maintain ISO 9001: 2015 certificate.	2	/3
2.2	Is there a system to ensure that Quality Manual is regularly revised ?	There was a system to ensure that Quality Manual was regularly revised.	2	/3
2.3	Is the document management system documented, to ensure documents affecting quality are controlled, managed, accessible and used in appropriate areas?	The document management system was documented, to ensure documents affecting quality were controlled, managed, accessible and used in appropriate areas.	3	/3
2.4	Is there a Master List of Documents with indication of established dates and revisions?	There was a Master List of Documents with indication of established dates and revisions.	3	/3
2.5	Is documentation from customer available, and controlled so that only most current external documents are available?	Documentation from customer was available, and controlled according to document control procedure. Only most current external documents were found during audit.	3	/3
2.6	Is there a system in place to ensure that document change is applied and effective?	There was a system in place to ensure that document change was applied and effective.	3	/3
2.7	Is the document change system controlled using IT system?	The document change system was controlled using IT system.	2	/3
Picture(s)				
				
Quality manual		Document control procedure		



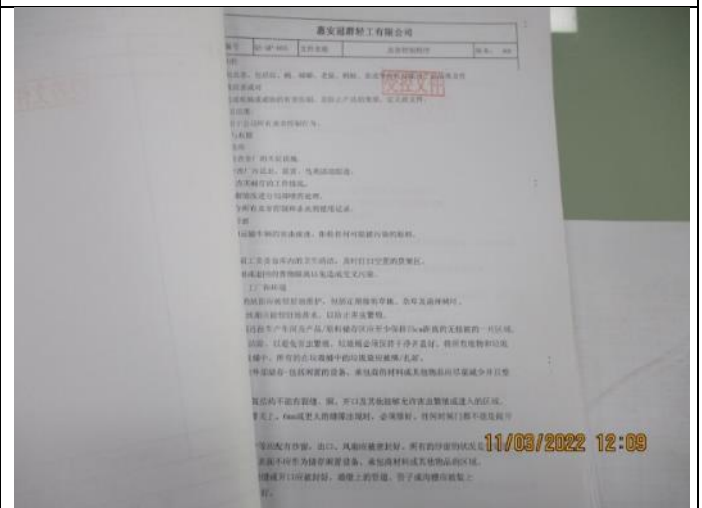
Record control procedure



Nonconforming product control procedure



Corrective and preventive action control procedure

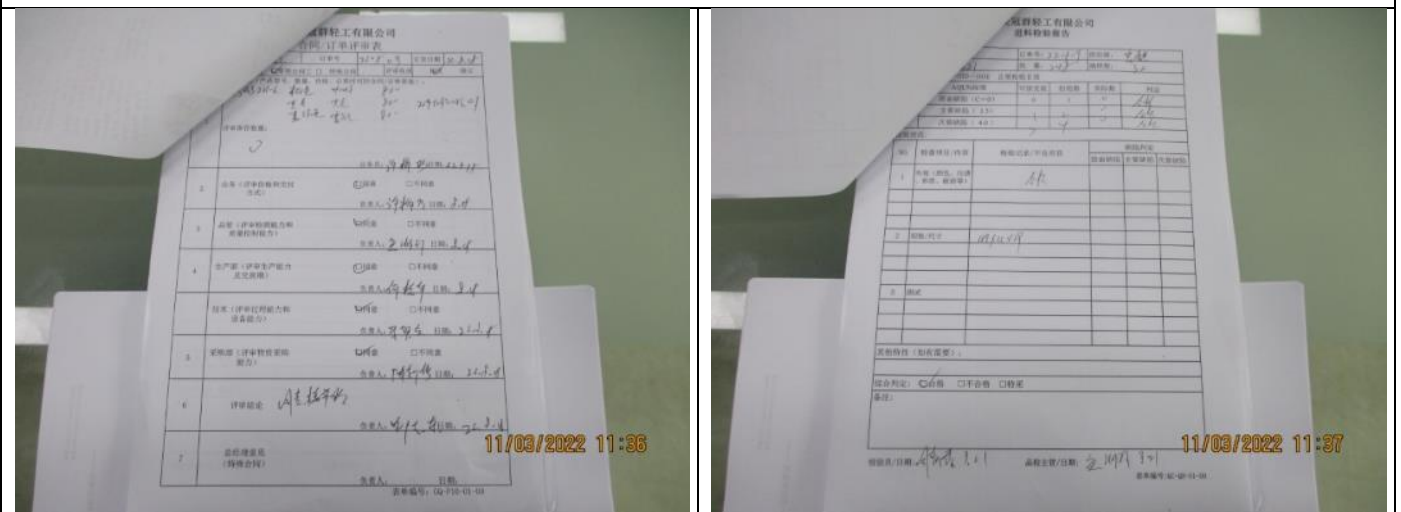


Internal audit control procedure

Control of Records		
Questions	Findings/Comments	Score
2.8 Are all records for topics affecting quality kept and with relevant information?	<p>QA manual was established for incoming inspection, in-process inspection and final inspection.</p> <p>For incoming inspection: I: For fabric material, the factory conducted 4-point system inspection, Lots quantity <= 500 yard, the factory should conduct 100% inspection; Lots quantity > 500 yard, the sample size should be 10% per lot; And the accepted points per 100 square yards for each roll should be less than 20 points etc.;</p>	1 /3

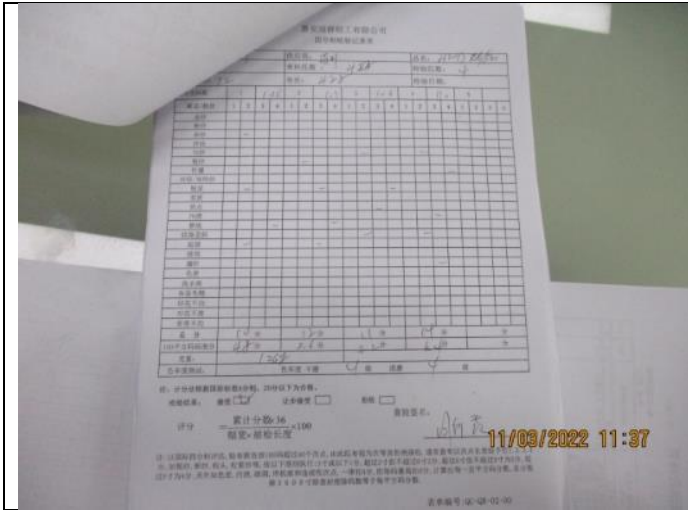
		<p>II: For other materials, the factory conducted sampling inspection according to MIL-STD-105E, Level: II, AQL: 0/1.5/4.0; II: Testing reports from the 3rd party were available.</p> <p>2. For in-process inspection: I: The factory conducted first article inspection for each process; II: The factory conducted sampling inspection based on MIL-STD-105E, Level II, AQL: 0/1.5/4.0 on cutting pieces; III: The factory conducted patrol inspection for each process, once per 2 hours, at least 20 pcs per once; IV: The factory also conducted 100% in-line inspection after sewing process.</p> <p>3. For Random final inspection, the factory should conduct inspection according to MIL-STD-105E, Level: II, AQL: 0/1.5/4.0.</p> <p>But found: No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained. 没有保留珍珠棉、气泡袋、胶骨的来料检验记录。</p>		
2.9	Are records clear, legible, stored in a way to prevent loss, and easily retrievable regardless of age?	Records were clear, legible, stored in a way to prevent loss, and easily retrievable regardless of age.	3	/3

Picture(s)



Sample review record

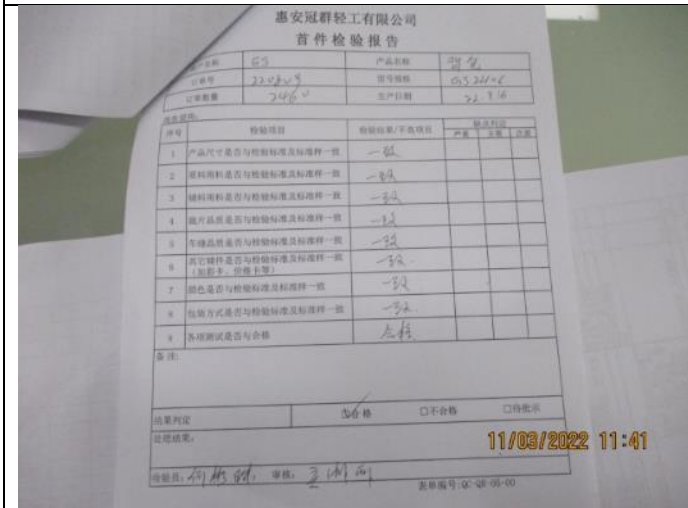
Incoming inspection record



Incoming inspection record



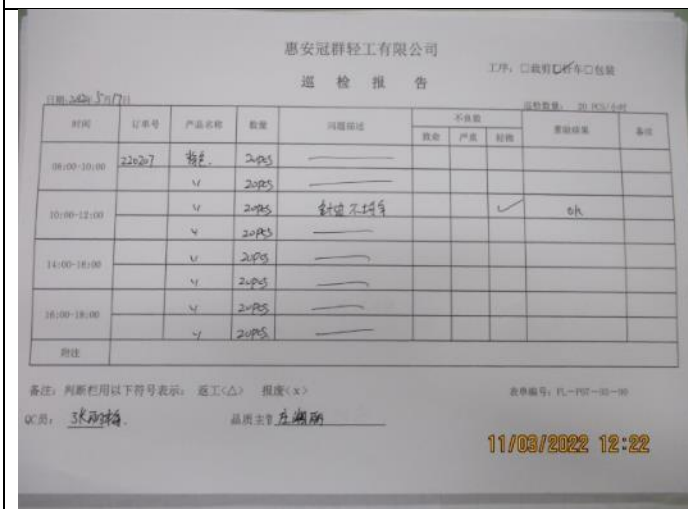
Incoming inspection record



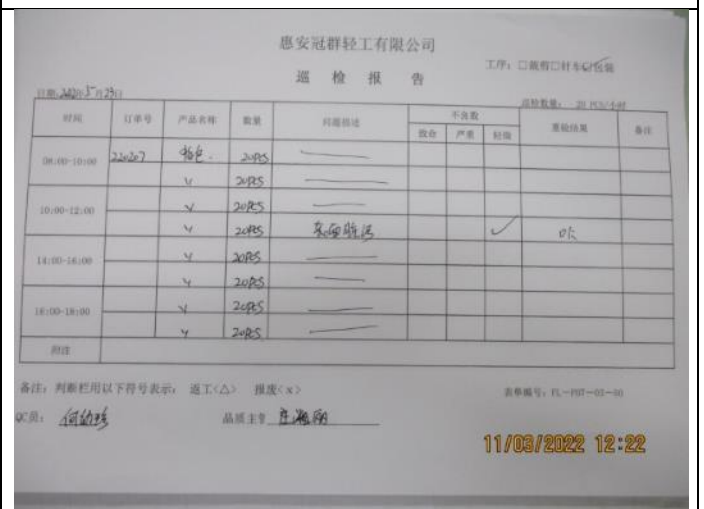
First article inspection record



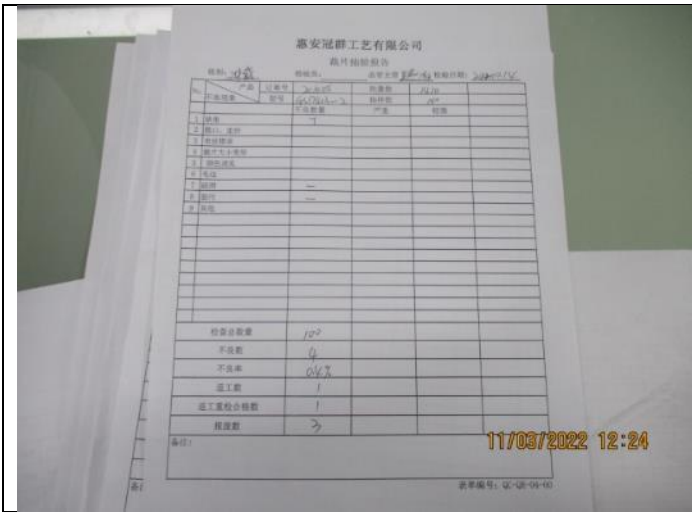
In-process inspection record



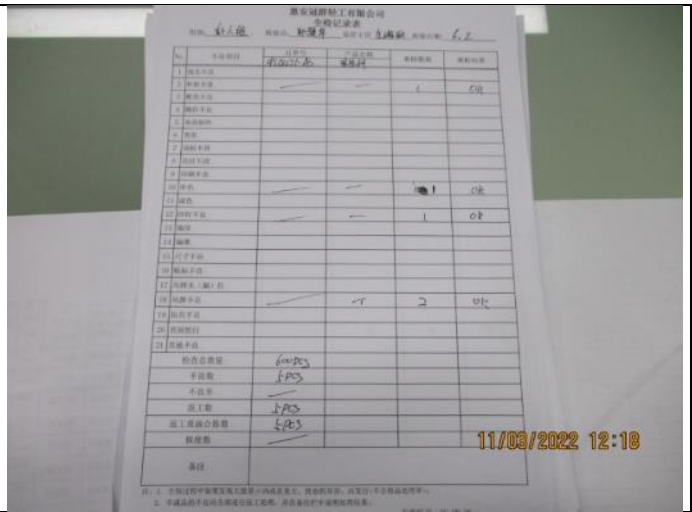
In-process inspection record



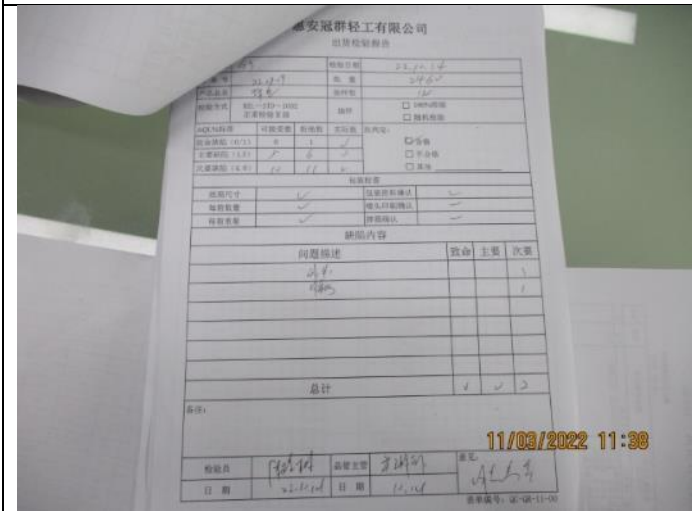
In-process inspection record



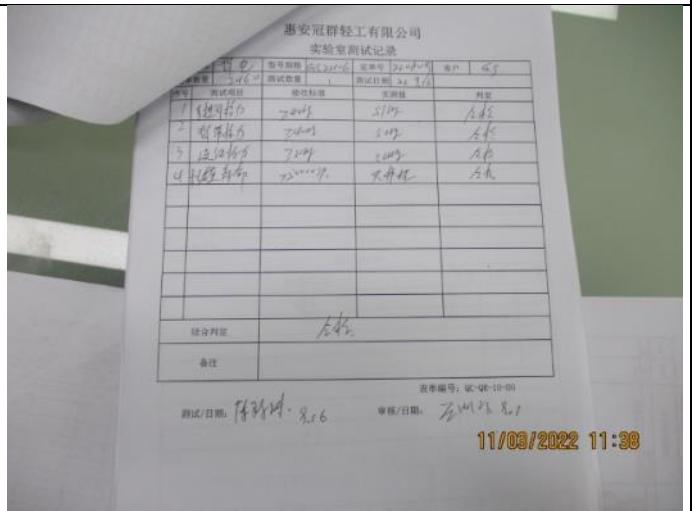
In-process inspection record



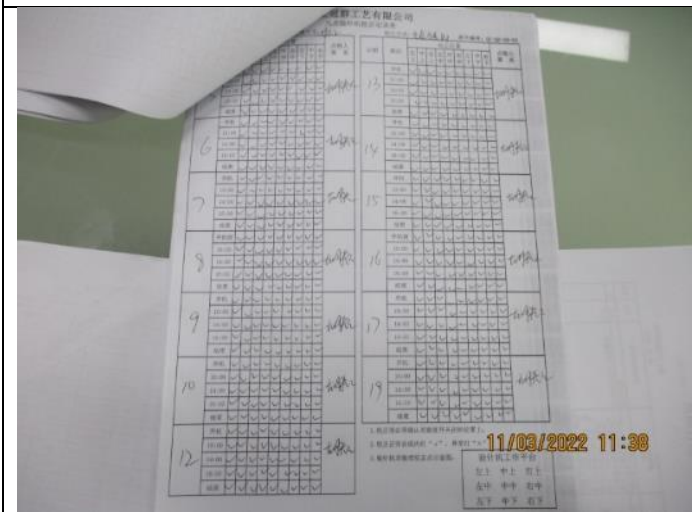
In-process inspection record



Final inspection record



Internal testing record



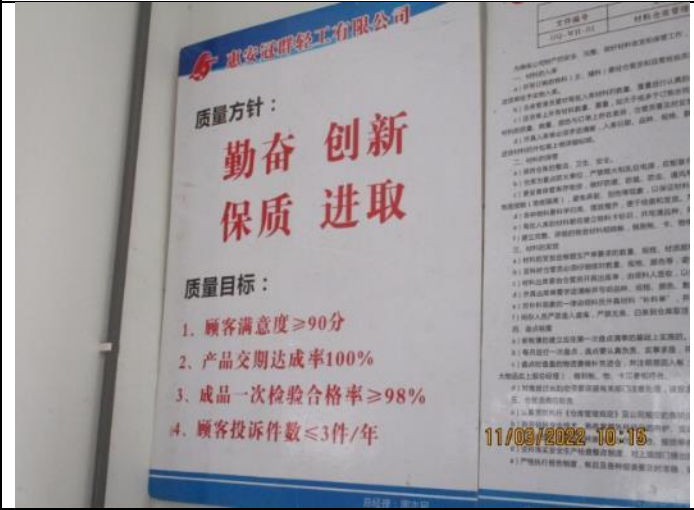
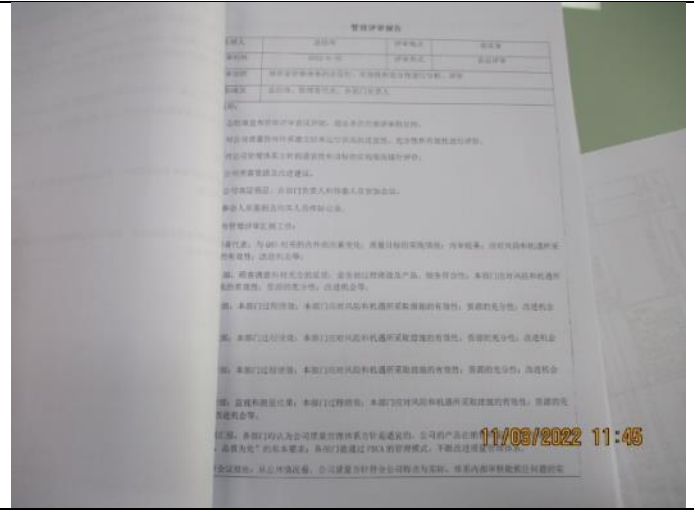
9 point calibration record



Finished product metal detection record

Commitment to Quality, Quality Policy and Responsibility				
Questions		Findings/Comments		Score
2.10	Is there a quality policy defined by factory (please describe).	Quality policy was defined by factory in quality manual. The policy was "Hardworking, Innovation, Guarantee quality, Aggressive".		3 /3
2.11	Are responsibilities of all employees that effect or assure quality been defined?	Responsibilities of all employees that effect or assure quality had been defined.		3 /3
2.12	Is the quality policy deployed and training implemented? Are employees aware of quality policy?	The training on the quality policy was implemented and most employees were aware of quality policy.		3 /3
Picture(s)				
		Nil		
Quality policy and goals				

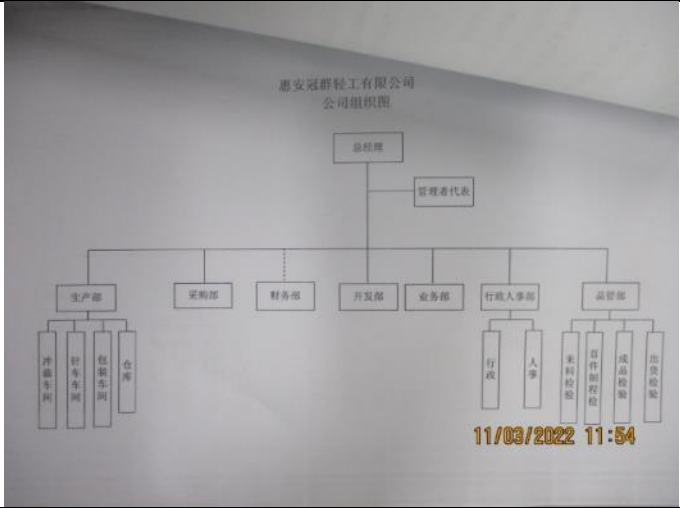
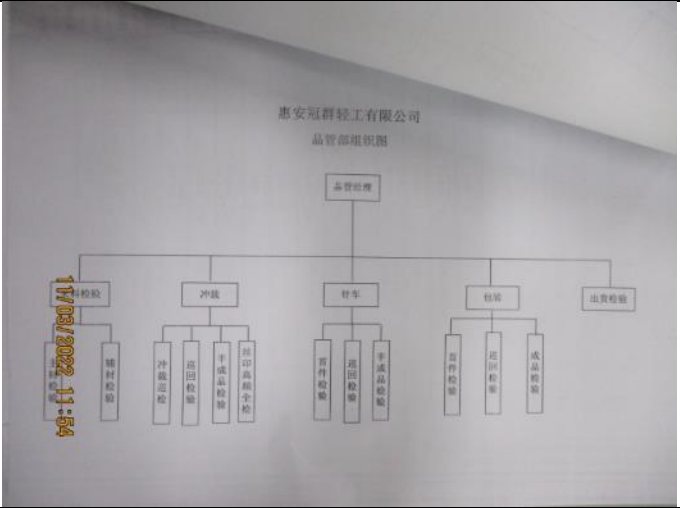
Planning and Management Review				
Questions		Findings/Comments		Score
2.13	Are quality goals defined (yield improvement, defect rate,...)? Please describe.	Quality goals were defined in quality manual. Delivery-check qualified rate should be equal or higher than 98%; Customer satisfaction should be equal or higher than 90; Delivery on-time rate should be equal to 100%; Number of customer complaints should be equal or less than 3.		3 /3
2.14	Are quality plans with defined schedules and actions to be taken available?	The quality plans with defined schedules and actions to be taken were available.		3 /3
2.15	Is Management Review regularly planned, and including performance, customer issues?	The factory established management review procedure, which defined that management review should be conducted at least annually, and management review should include		3 /3

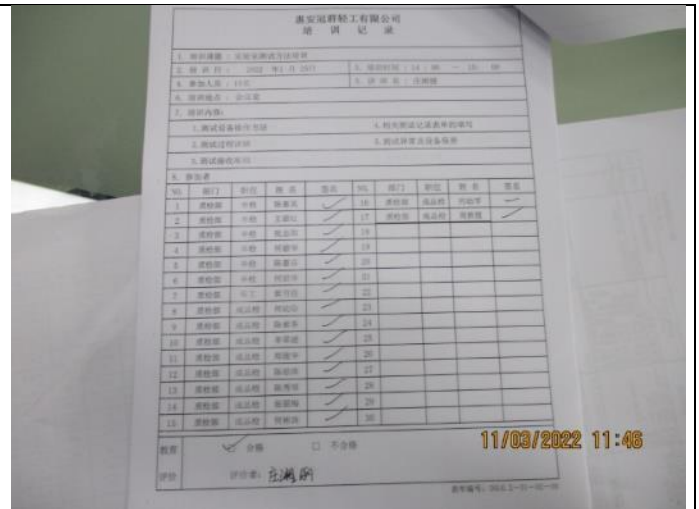
		performances, objectives, and definition of corrective/preventive action plan etc.		
2.16	Is Management Review including review of performance vs. objectives, and definition of corrective/preventive action plan?	Management Review included review of performance vs. objectives, and definition of corrective/preventive action plan.	3	/3
Picture(s)				
				
Quality policy and goals		Management review control record		

Special Remarks on this section
 No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained.

Actual Score	Theoretical Max
43	/48

Part 3 Resources Management

Human Resources				
Questions		Findings/Comments		Score
3.1	Is there a clear Organizational structure, and organization chart in use?	The factory had an organization chart, each department was clearly identified. The organization chart was available for employees. Interviewed staffs knew the responsibility of their supervisor / department director.		3 /3
3.2	Is there a training process in place to ensure that all workers receive training?	The training process was in place to ensure that all workers receive training.		3 /3
3.3	Are training recorded, with training records/certificates readily available for review?	1. Training plan in 2022 was established and many training records in 2022 were provided to review. 2. Through on-site observation & employee interview, the employee could skillfully operate the production equipment.		3 /3
3.4	Is there any regular assessment and re-training when necessary as part of training process?	Based on workers interview, there was the regular assessment and re-training when necessary, as part of training process, but the records were not kept in place.		2 /3
Picture(s)				
				
Organization chart		QC department organization chart		



Training schedule

Training record

Purchasing				
Questions		Findings/Comments		Score
3.5	Is there a defined supplier qualification system documented?	Suppliers selection/ evaluation/ assessment control procedure was established.		3 /3
3.6	Is the selection/evaluation process for suppliers including regular audits of quality issues?	1. Factory had written supplier assessment management procedure. 2. Suppliers were evaluated periodically, relevant approved supplier list and supplier assessment records were available.		3 /3
3.7	Are "Critical" components identified, and/or method to define "Key" suppliers in place?	"Critical" components were not identified, and there was no method to define "Key" suppliers in place. "关键"组件没有被识别, 也没有方法来定义"关键"供应商。		0 /3
3.8	Is there a system defined to ensure that any change in suppliers/materials is communicated efficiently to customer?	There was no system defined to ensure that any change in suppliers/materials was communicated efficiently to customer. 没有建立相应的系统来确保供应商/材料的任何变化都能有效地传达给客户。		0 /3
3.9	Is there an evaluation system for suppliers, based on documented performance results (quality rate, delivery,...)?	1. Factory had written supplier assessment management procedure. 2. Suppliers were evaluated periodically, relevant approved supplier list and supplier assessment records were available.		3 /3
3.10	Is there evidence that suppliers are requested to provide evidence of corrective actions in case of failure?	The corrective & preventive action control procedure was established. But there was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure. 没有证据显示, 需要供应商提供相应的纠正措施。		1 /3

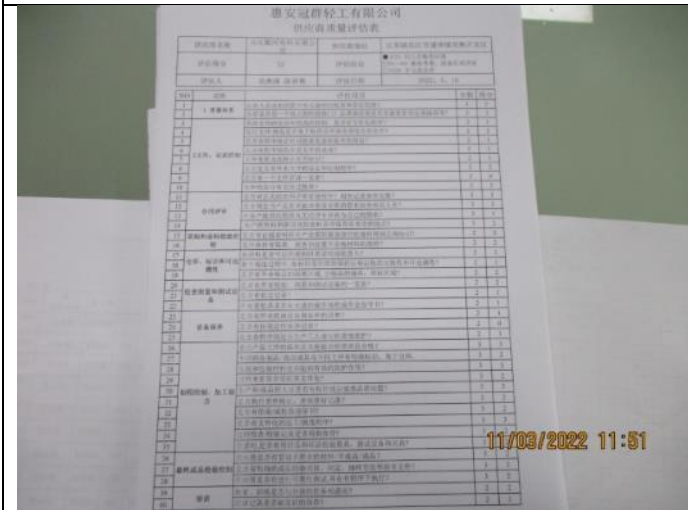
Picture(s)



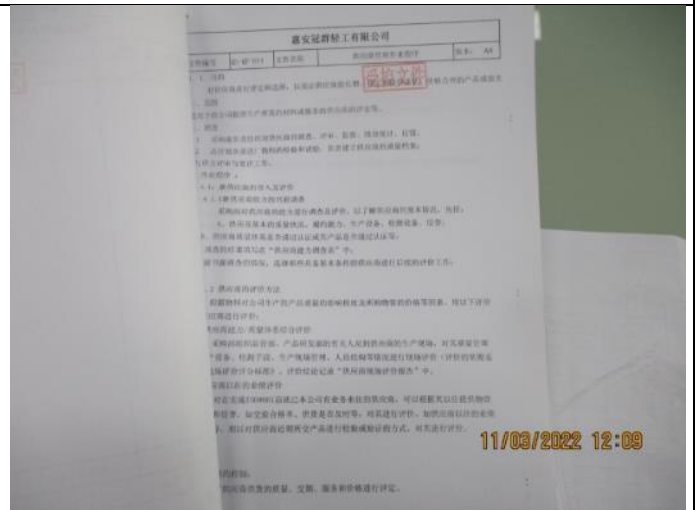
Approves supplier list



Assessment score sheet



Supplier assessment record



Supplier management control procedure

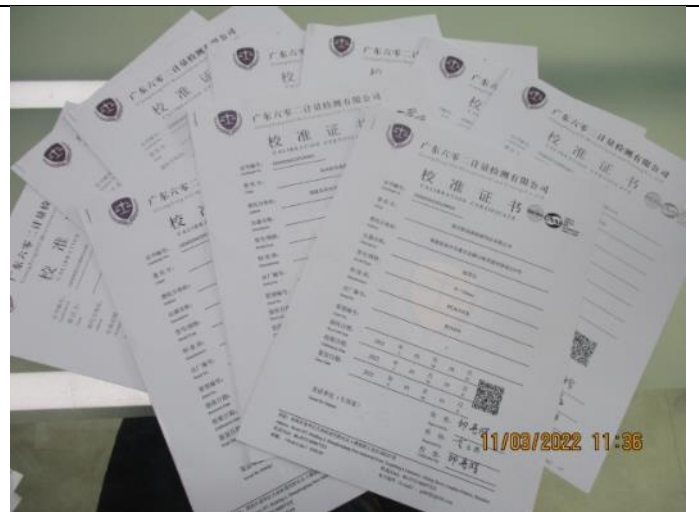
Control of Monitoring and Measuring Devices

Questions		Findings/Comments	Score	
3.11	Is there a process in place to register all gauges and measuring devices, including identification, last calibration date/due date, how to perform calibration?	There was a process in place to register all gauges and measuring devices, including identification, last calibration date/due date, how to perform calibration.	3	/3
3.12	Are all evidences of calibration available for gauges and measuring devices (external certificates, internal records)?	1. The test equipment and tools, such as tension meter/ Zipper Reciprocating Pull testing Machine/ Electric scale/ Shaking testing machine etc. were appropriate and with sufficient sensitivity. 2. The internal inspection equipment was	3	/3

		available and it was calibrated by Guangdong 602 Measurement and Testing Co., Ltd.		
3.13	If calibration performed internally, is there evidence (training certificates) that personnel in charge has relevant qualifications?	Not applicable. no equipment was calibrated internally.	N/A	/3
3.14	Are gauge R&R (repeatability and reproducibility) completed for all gauges on control plan?	Products in factory were Bag products etc., the gauge R&R was not applicable. Factory didn't have Gauge R&R analysis.	N/A	/3
3.15	Is there an internal laboratory/QC room in the factory? Is it certified/accredited by a 3rd party?	There was an area for internal inspection and testing, in which some inspection and testing equipment was available. Remark : It is not certified by a 3rd company.	2	/3

Picture(s)

序号	设备名称	设备编号	型号/规格	检定/校准周期	检定/校准日期	责任人	备注
1	拉力试验机	11193	05-9034	1年	√	汪海刚	
2	标准砝码	00000274	0.01-100g	1年	√	汪海刚	
3	钢板尺	5009	0-1000mm	1年	√	汪海刚	
4	游标卡	81430	0-100mm	1年	√	汪海刚	
5	电子天平	319	6002	1年	√	汪海刚	
6	电子秤	A209	1.5kg	1年	√	汪海刚	
7	经纬仪	100700101	00-030	1年	√	汪海刚	
8	游标卡尺	1008	0-100mm	1年	√	汪海刚	
9	标准量块	0409	/	1年	√	汪海刚	
10	全自动卧式拉力计	0004	20T-5000C	1年	√	汪海刚	



Measurement list

Calibration report



Tension meter



Zipper Reciprocating Pull testing Machine



Inspection equipment



Shaking testing machine



Calibration tag

Nil

Special Remarks on this section

1. "Critical" components were not identified, and there was no method to define "Key" suppliers in place.
2. There was no system defined to ensure that any change in suppliers/materials was communicated efficiently to customer.
3. There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure.

Actual Score	Theoretical Max
29	/39

Part 4 Stock Management

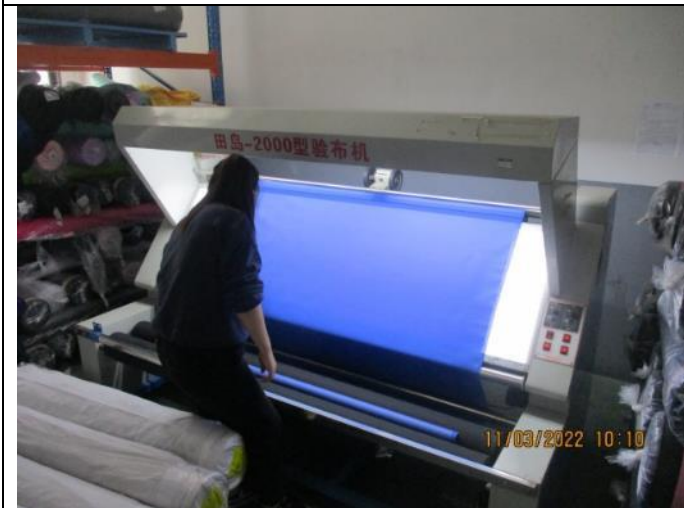
Incoming Materials Storage				
Questions		Findings/Comments		Score
4.1	Is there a logistic method in used in the factory? Which one? (Kanban, FIFO...)	Most raw materials were identified with materials/ products description, receiving date, inspector status, inspection date & quantity etc. So, First in and First out (FIFO) policy was well implemented on all material.		3 /3
4.2	Is the stock management integrated to an ERP system?	The stock management was integrated to an ERP system		3 /3
4.3	Is storage capacity for incoming materials sufficient based on observation?	Storage capacity for incoming materials was sufficient based on observation.		3 /3
4.4	Is there a reception area clearly marked and away from assembly line and stock area?	There was a reception area clearly marked and away from assembly line and stock area.		3 /3
4.5	Are the materials and boxes in storage area in good conditions based on observation?	The materials and boxes in storage area were in good conditions based on observation. But found, 1. Around 10% of different color inventory fabric materials was stored together without any proper segregation. 10%左右的不同颜色的库存布料堆放在一起，没有进行隔离放置。 2. All the pearl wool in the warehouse was put on the ground. 所有的珍珠棉直接放置在地上。		1 /3
4.6	Is there any material needing special conditions of storage (temperature, humidity), and if yes, are the conditions controlled?	Not applicable, the main products in the factory were Bag products etc.		N/A /3
Picture(s)				
				
Fabric material storage		Identification		



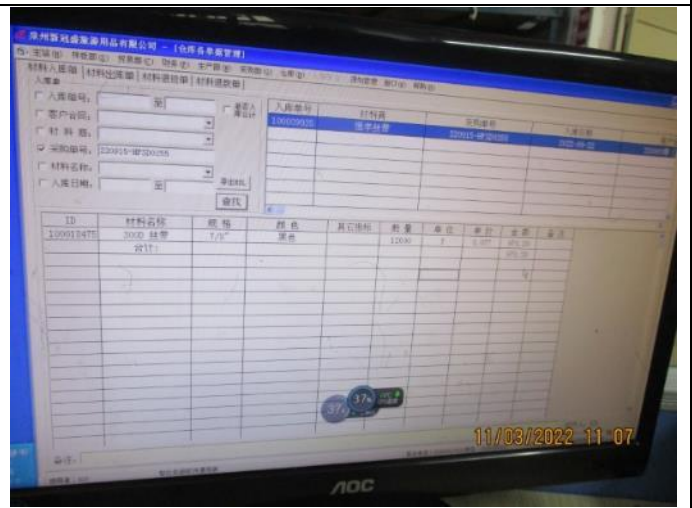
Accessories storage



Identification



Fabric inspection machine



ERP system



Around 10% of different color inventory fabric materials was stored together without any proper segregation



All the pearl wool in the warehouse was put on the ground

In-Process Storage				
Questions		Findings/Comments	Score	
4.7	Are the storage areas for semi-finished products and Non-compliant products clearly defined?	1. Nonconforming products control procedure was established. 2. Factory had stopped those NC products to use in production for those with failed in-process inspection. 3. The non-conforming products storage were identified & segregated in production workshop.	3	/3
4.8	Is the size of workshops and storage areas sufficient based on observation?	The size of workshops and storage areas were sufficient based on observation.	3	/3
4.9	Does the system ensure traceability throughout the production process? Is production workshop managed linked to ERP?	Production workshop managed was linked to ERP.	3	/3
4.10	Is the identification system for semi-finished products well defined and implemented?	Most semi-finished products were identified with products description, process & quantity etc.	2	/3
4.11	Are the semi-finished products in storage area in good conditions based on observation?	The semi-finished products in storage area were in good conditions based on observation. 1. 10% semi-finished products in cutting workshop were put against the wall. 10%左右的裁片靠墙放置。 2. Around 20% of semi-finished products in the sewing workshop were put against the wall & windows. 20%左右的车缝半成品靠墙、靠窗放置。 3. The semi-finished products in the peeling station were put on the ground directly. 削皮的半成品直接放置在地面上。	1	/3
4.12	Is there a special team dedicated to preparing kits and dispatching materials to assembly workshop?	There was a special team dedicated to preparing bundles and dispatching materials to assembly workshop.	3	/3
4.13	Is the kitting and dispatching organized with an ERP system to ensure the relevant components are used for assembly? If not how the team is aware about when to feed the assembly with new parts?	The bunding and dispatching were organized to ensure the relevant components were used for assembly.	3	/3
4.14	Is the kitting and dispatching process showing evidences of actions taken to improve speed and avoid mistakes from workers?	The materials preparing team prepared kits according to production orders, and kits were stored on different areas by different orders and avoid mistakes from workers.	3	/3
Picture(s)				



Nonconforming products were identified & segregated



Die-cutting workshop



Sewing workshop



Packing workshop



Production workshop managed was linked to ERP



Cutting pieces storage



Semi-finished products storage in the sewing workshop



Identification



10% semi-finished products in cutting workshop were put against the wall





Around 20% of semi-finished products in the sewing workshop were put against the wall & windows



The semi-finished products in the peeling station were put on the ground directly

Nil

Finished Products				
Questions		Findings/Comments	Score	
4.15	Are the storage areas for finished products clearly defined?	The storage areas for finished products were clearly defined.	3	/3
4.16	Is the size of storage area/warehouse for finished products sufficient based on observation?	The size of storage area/warehouse for finished products were sufficient based on observation.	3	/3
4.17	Are the conditions of storage controlled to ensure sufficient the products will not be deteriorated?	Finished products were stored properly.	3	/3
4.18	Is there a sufficient number of loading decks, with relevant conditions of protections against rain and product deterioration during loading?	There was one loading deck, with relevant conditions of protections against rain and product deterioration during loading.	3	/3
Picture(s)				
				
Finished products storage		Un-loading & Loading area		

Special Remarks on this section

1. Around 10% of different color inventory fabric materials was stored together without any proper segregation; All the pearl wool in the warehouse was put on the ground.
2. 10% semi-finished products in cutting workshop were put against the wall; Around 20% of semi-finished products in the sewing workshop were put against the wall & windows ; The semi-finished products in the peeling station were put on the ground directly.

Actual Score	Theoretical Max
46	/51

Part 5

Incoming Materials Inspection

Quality Control upon Reception				
Questions		Findings/Comments	Score	
5.1	Is the system for IQC (quality inspection upon reception) defined in written form, and included in standard operating procedures?	Incoming inspection procedure and instructions in written were provided for review during audit.	3	/3
5.2	Is the scope of IQC, frequency, sampling method well defined and relevant?	<p>For incoming inspection: I: For fabric material, the factory conducted 4-point system inspection, Lots quantity <= 500 yard, the factory should conduct 100% inspection; Lots quantity > 500 yard, the sample size should be 10% per lot; And the accepted points per 100 square yards for each roll should be less than 20 points etc.;</p> <p>II: For other materials, the factory conducted sampling inspection according to MIL-STD-105E, Level: II, AQL: 0/1.5/4.0; II: Testing reports from the 3rd party were available.</p> <p>But found: No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained. 没有保留珍珠棉、气泡袋、胶骨的来料检验记录。</p>	1	/3
5.3	Is there a QC room, separated from workshop, and clearly defined?	IQC station was separated from workshop, and was clearly defined.	2	/3
5.4	How many staff is dedicated to IQC? Are they suitably trained based on interview and observation?	<ol style="list-style-type: none"> There was 1 IQC. Through on-site observation & employee interview, the employee could skillfully operate the production equipment. 	3	/3
5.5	Does factory keep records of incoming quality inspection? How? (Paper or Computer)	The factory kept paper records of incoming quality inspection for raw materials.	2	/3
5.6	Is the system in case of non-compliance defined, and understood by IQC staff?	<ol style="list-style-type: none"> The non-conforming materials control procedure was established. The non-conforming materials should be identified & segregated. Factory had stopped those NC materials to use in production for those with failed incoming inspection. 	2	/3
5.7	Is there an area for rejected parts? Is clearly defined and without mixed materials? If necessary, is it closed with controlled access?	<ol style="list-style-type: none"> The non-conforming materials control procedure was established. The non-conforming materials storage in the warehouse was identified & segregated. 	2	/3

5.8	Are parts correctly identified as pass or failed after QC inspection?	Parts were correctly identified as pass or failed after QC inspection.	3	/3
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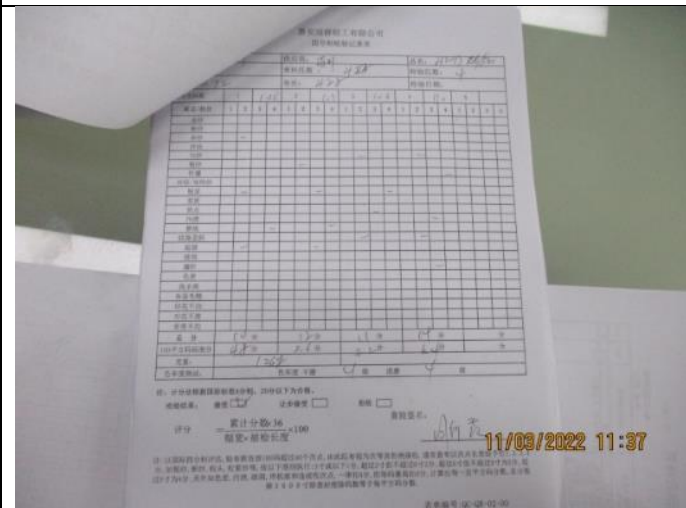
Picture(s)



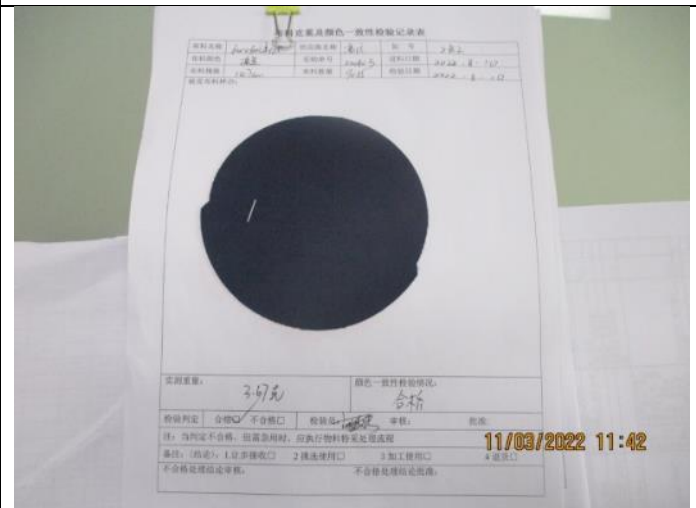
Fabric inspection machine





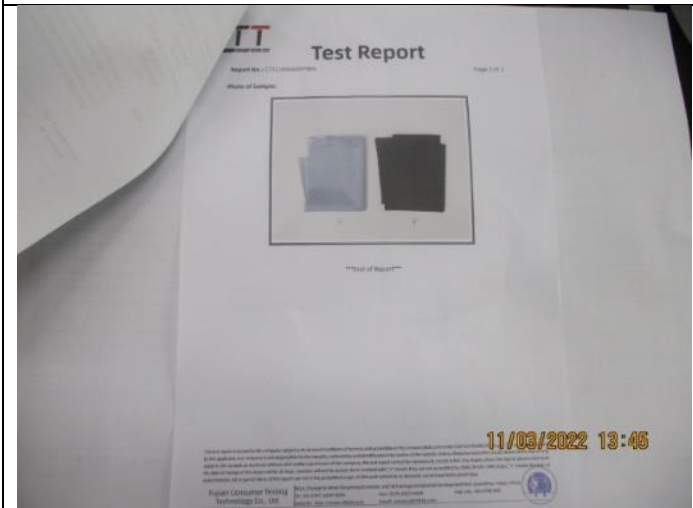
IQC station



Incoming inspection record




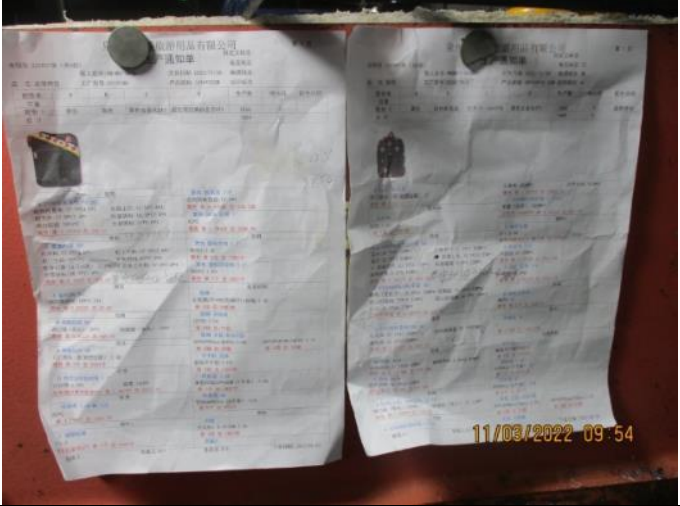
Incoming inspection record

 <p>11/03/2022 10:06</p>	 <p>11/03/2022 13:44</p>
<p>Nonconforming material storage</p>	<p>Testing report on raw material</p>
 <p>11/03/2022 13:45</p>	<p>Nil.</p>
<p>Testing report on raw material</p>	

Special Remarks on this section
 No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained.

Actual Score	Theoretical Max
18	/24

Part 6 Production Process

Workshops Organization				
Questions		Findings/Comments	Score	
6.1	Are working instructions available for each machine?	Working instructions were available.	3	/3
6.2	Is the production planning defined and available in workshop?	The production planning was defined and available in workshop.	3	/3
6.3	Does factory follow production performance of each machine?	Factory followed production performance of each machine.	3	/3
6.4	Is workshop organization, cleanliness, and tidiness, optimized for performance (5S)?	Drinking cups were found in the production workshop. 生产现场发现水杯。	0	/3
6.5	Is machine daily maintenance status and condition identified clearly in workshop?	Machine daily maintenance status and condition was identified clearly in workshop.	3	/3
6.6	Is there a defined process to set-up machines and start production? Who is responsible to give a green light to mass production? (Name and title)	Based on management interview, quality manager (Mr. Zheng Junhua) was responsible to give a green light to mass production.	3	/3
6.7	Are variables of production defined clearly (temperature, speed...) and monitored during production?	Not applicable, the main process in the factory was Die-cutting/ Sewing / Sacking.	N/A	/3
Picture(s)				
				
Work instruction on site		Production order		



Die-cutting workshop



Sewing workshop



Packing workshop



Maintenance record



Drinking cups were found in the production workshop

Nil

Quality Control during Production				
Questions		Findings/Comments	Score	
6.8	Is there a QC procedure for inspection before / during production written and available to relevant staff?	There was a QC procedure for inspection before/ during production written and available to relevant staff.	3	/3
6.9	How many QC staffs are there for in-line QC? Are they easily identified? What are the powers of the QC people toward the line in case of NCs found?	1. There 3 staffs for in-process inspection. 2. The QCs would report to quality manager when found major problem, the quality manager had sufficient authority to stop production.	3	/3
6.10	Is equipment necessary to perform quality control during production available on site and readily accessible to relevant staff?	Equipment necessary to perform quality control during production was available on site and readily accessible to relevant staff.	3	/3
6.11	Are first parts checked and validated before production? By who? Are the responsible not belonging to production team?	1. The IPQC had a signed approval reference samples for in-process inspection. 2. First article was available.	3	/3
6.12	Describe the frequency? (Every morning, twice a day, before each shift...) Define the tests that are done for the first parts to validate the mass production?	1. The work instruction defined that first article inspection should be conducted before each shift, and mass production could be started only when first parts passed inspection. 2. First article was available on site.	3	/3
6.13	Is there any random QC check during production? If yes, what is the frequency and sampling size used?	For in-process inspection: I: The factory conducted first article inspection for each process; II: The factory conducted sampling inspection based on MIL-STD-105E, Level II, AQL: 0/1.5/4.0 on cutting pieces; III: The factory conducted patrol inspection for each process, once per 2 hours, at least 20 pcs per once; IV: The factory also conducted 100% in-line inspection after sewing process.	3	/3
6.14	Are there records for all the above checks written and kept in factory?	There records for all the above checks were written and kept in factory.	3	/3
6.15	Are there steps of control for 100% of products during production? If applicable, are they well implemented?	The factory conducted 100% in-line inspection after sewing process.	3	/3
6.16	In case of Non-compliance detected during production, is there a defined process defined and well understood?	1. Factory had written Non-conforming Product Control Procedure and Corrective Actions & Preventive Action Control Procedure. 2. Factory had stopped those NC products to use in production for those with failed in-process inspection.	3	/3
6.17	Are the Non-compliant products adequately separated, identified and disposed of?	The non-conforming product storage in production workshop were identified & segregated.	3	/3
Picture(s)				



IPQC in die-cutting workshop



IPQC in sewing workshop



IPQC in packing workshop



Reference sample



Reference sample



Reference sample



100% in-line inspection after sewing process



Nonconforming products were identified & segregated

Special Remarks on this section



Drinking cups were found in the production workshop.

Actual Score	Theoretical Max
45	/48

Part 7

Packing and Quality Control before Shipment

Packing Line Organization				
Questions		Findings/Comments		Score
7.1	Are packing methods clearly defined to ensure product protection and instructions available?	Packing methods were clearly defined to ensure product protection and instructions available.		3 /3
7.2	Is line organization, cleanliness, and tidiness, optimized for performance (5S) to ensure product cannot be deteriorated?	Line was organized, cleanliness, and tidiness, optimized for performance (5S) to ensure product could not be deteriorated.		3 /3
Picture(s)				
				
Reference sample		Packing instruction		
		Nil		
Packing workshop				

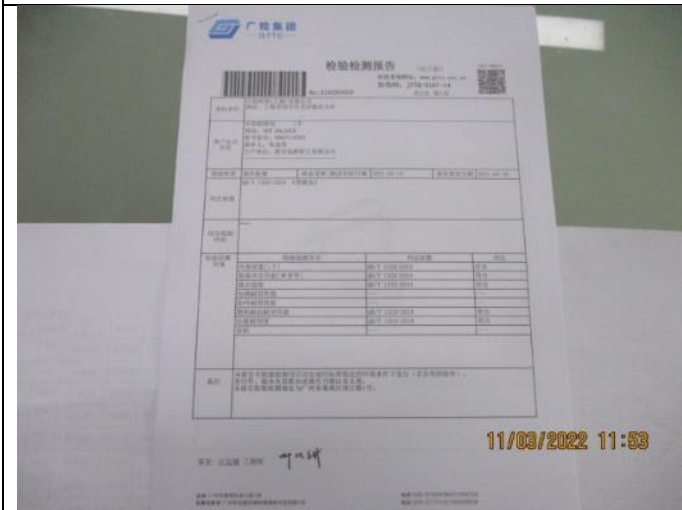
Quality Control Before shipment				
Questions		Findings/Comments	Score	
7.3	Is there a standard for final quality inspection before shipment defined in factory including sampling size, AQL, defect classification (Critical/Major/Minor)?	For Random final inspection, the factory should conduct inspection according to MIL-STD-105E, Level: II, AQL: 0/1.5/4.0.	3	/3
7.4	How many QC staffs are in charge of Final Quality Inspection? Are they in sufficient number, easily identified, and suitably trained based on interview and observation?	1. There was 1 QC staff in charge of final inspection. 2. Through on site observation & employee interview, the employee could skillfully operate the production equipment.	3	/3
7.5	Is necessary equipment to perform final inspection available in factory and readily available for relevant staff?	The test equipment and tools, such as tension meter/ Zipper Reciprocating Pull testing Machine/ Electric scale/ Shaking testing machine etc. were appropriate and with sufficient sensitivity.	3	/3
7.6	Are records of final inspection kept and with enough information to be linked to the batch inspected and with enough information recorded?	Records of final inspection were kept and with enough information to be linked to the batch inspected and with enough information recorded.	3	/3
7.7	Is there a clearly defined process in case of fail final inspection? Will products be clearly identified and separated, and corrective actions taken?	1. Non-conforming products control procedure was established. 2. Factory had stopped those NC products to ship in storage for those with failed final inspection. 3. The non-conforming products were identified & segregated.	3	/3
7.8	Is factory using their own QC team? Who is responsible to approve final shipment quality? Is factory working with 3 rd party company? If yes, which frequency?	The factory used their own QC team; Quality manager was responsible to approve final shipment quality. Factory was working with 3rd party company (SGS, ITS and BV etc.) according to client's requirements (many times every year).	3	/3
Picture(s)				
				
Tension meter		Zipper Reciprocating Pull testing Machine		



Calibration tag



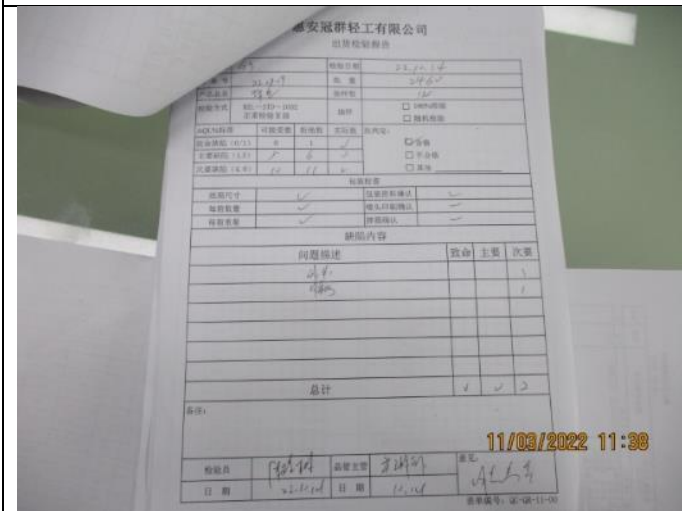
Shaking testing machine



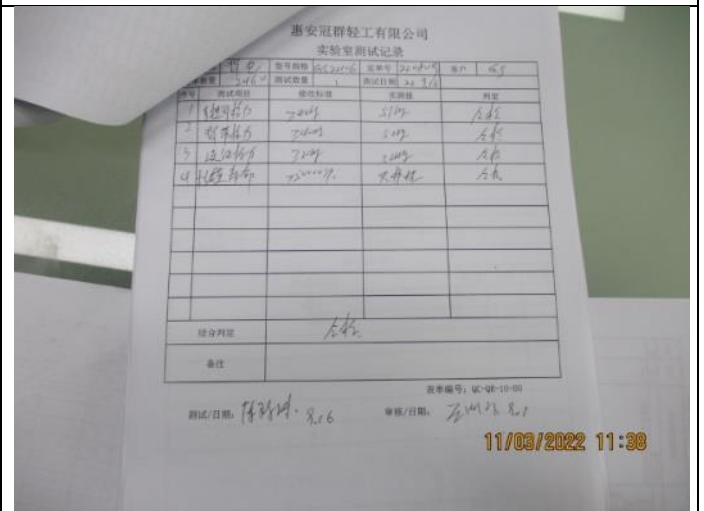
Testing report on finished product



Testing report on finished product



Final inspection record



Internal testing record

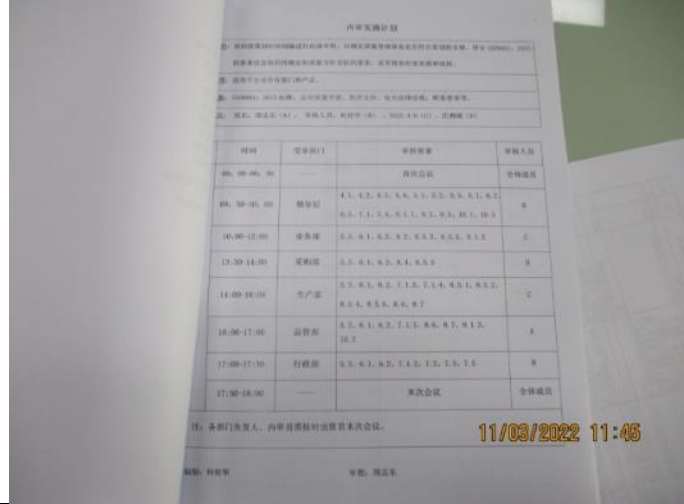

Special Remarks on this section

Nil.

Actual Score	Theoretical Max
24	/24

Part 8

Measurement, Analysis and Improvement

Internal Audit				
Questions		Findings/Comments		Score
8.1	Is there a documented internal audit process?	Internal audit control procedure was established.		3 /3
8.2	Are internal audits performed at least once per year?	Internal audit was performed once per year and records showed that last internal audit was conducted on 20-Jun-2022.		3 /3
8.3	Are internal audits recorded, and with proof that it has been performed according to plan, for whole process, and by auditors with relevant qualifications (certified)?	Internal audit was performed once per year and records showed that last internal audit was conducted on 20-Jun-2022. But found: Relevant qualifications for internal auditor was not available. 无法提供内审员的证书。		1 /3
8.4	Are issues found during internal audits addressed with corrective actions, and efficiency reviewed and documented?	Issues were found during internal audits addressed with corrective actions, and efficiency reviewed and documented.		3 /3
Picture(s)				
 <p>Internal audit control record</p>		 <p>Internal audit control procedure</p>		

Monitoring and Measurement of Process				
Questions		Findings/Comments		Score
8.5	Are there Statistical Process Control charts existing for all critical characteristics?	There were no Statistical Process Control charts existing for all critical characteristics. 没有保留关键参数的统计过程控制图表。		0 /3
8.6	Are out of control conditions identified and brought back to control in timely manner?	No Statistical Process Control, it is not applicable.		N/A /3

8.7	Are there any Response Plan documented and readily available?	No Statistical Process Control, it is not applicable.	N/A	/3
8.8	Is factory able to prove that Process Capability has been calculated using statistical analysis?	The factory did not provide statistical analysis records of Process Capability. 工厂没有提供工序能力统计分析记录。	0	/3
8.9	Does factory use Advanced Statistics to analyze data and define improvements?	The factory did not use Advanced Statistics to analyze data and define improvements.工厂没有使用高级的统计分析工具进行改善。	0	/3

Data Management and Continuous Improvement

Questions		Findings/Comments	Score	
8.10	Does factory collect and analyze data for suppliers performance, product performance?	The factory collected and analyzed data for suppliers performance, product performance.	3	/3
8.11	Is there evidence that improvement efforts are documented and recorded?	Improvement efforts were documented and recorded.	3	/3
8.12	Are corrective and preventive actions documented and recorded?	The corrective & preventive action control procedure was established. But there was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure. 没有证据显示，需要供应商提供相应的纠正措施。	1	/3

Special Remarks on this section

1. Relevant qualifications for internal auditor was not available.
2. There were no Statistical Process Control charts existing for all critical characteristics.
3. The factory did not provide statistical analysis records of Process Capability.
4. The factory did not use Advanced Statistics to analyze data and define improvements.
5. There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure.

Actual Score	Theoretical Max
17	/30

Part 9

Corrective Action Plan

Client	Babyone - remmidemmi GmbH	QIMA Service No	R-Cloud-22223825
Supplier	Huian Guanqun Light Industry Co., Ltd.	Auditor(s)	Sam Yang
Factory	Huian Guanqun Light Industry Co., Ltd.	Date	03-Nov-2022
Industry	Textile, Apparel, Footwear & Accessories	Country	China
Audit Type	Initial		

No.	Findings / Violations	Corrective action	Target completion date
2.8 5.2	No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained. 没有保留珍珠棉、气泡袋、胶骨的来料检验记录。	All records for topics affecting quality should be kept and with relevant information. 应保留所有影响质量的记录，并提供相关信息。	2-Jan-2023
3.7	"Critical" components were not identified, and there was no method to define "Key" suppliers in place. “关键”组件没有被识别，也没有方法来定义“关键”供应商。	"Critical" components should be identified, and there should be method to define "Key" suppliers in place. “关键”组件应该被识别，并且应该有定义“关键”供应商的方法。	2-Jan-2023
3.8	There was no system defined to ensure that any change in suppliers/materials was communicated efficiently to customer. 没有建立相应的系统来确保供应商/材料的任何变化都能有效地传达给客户。	There should be a system defined to ensure that any change in suppliers/materials was communicated efficiently to customer. 应建立相应的系统来确保供应商/材料的任何变化都能有效地传达给客户。	2-Jan-2023
3.10 8.12	There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure. 没有证据显示，需要供应商提供相应的纠正措施。	Suppliers should be requested to provide evidence of corrective actions in case of failure. 需要供应商提供相应的纠正措施。	2-Jan-2023
4.5	1. Around 10% of different color inventory fabric materials was stored together without any proper segregation. 10%左右的不同颜色的库存布料堆放在一起，没有进行隔离放置。 2. All the pearl wool in the warehouse was put on the ground. 所有的珍珠棉直接放置在地上。	Raw materials should be stored properly. 原材料应良好储存。	2-Jan-2023
4.11	1. 10% semi-finished products in cutting workshop were put against the wall. 10%左右的裁片靠墙放置。 2. Around 20% of semi-finished products in the sewing workshop were put against the	Semi-finished products should be stored properly. 半成品应良好储存。	2-Jan-2023

	<p>wall & windows. 20%左右的车缝半成品靠墙、靠窗放置。 3. The semi-finished products in the peeling station were put on the ground directly. 削皮的半成品直接放置在地面上。</p>		
6.4	<p>Drinking cups were found in the production workshop. 生产现场发现水杯。</p>	<p>Drinking cups should be forbidden in the production workshop. 生产车间禁止使用水杯。</p>	2-Jan-2023
8.3	<p>Relevant qualifications for internal auditor was not available. 无法提供内审员的证书。</p>	<p>Relevant qualifications for internal auditor should be available. 内审员应具备相关资质。</p>	2-Jan-2023
8.5	<p>There were no Statistical Process Control charts existing for all critical characteristics. 没有保留关键参数的统计过程控制图表。</p>	<p>There should be Statistical Process Control charts existing for all critical characteristics. 应保留关键参数的统计过程控制图表。</p>	2-Jan-2023
8.8	<p>The factory did not provide statistical analysis records of Process Capability. 工厂没有提供工序能力统计分析记录。</p>	<p>The factory should provide statistical analysis records of Process Capability. 工厂应提供工艺能力的统计分析记录。</p>	2-Jan-2023
8.9	<p>The factory did not use Advanced Statistics to analyze data and define improvements. 工厂没有使用高级的统计分析工具进行改善。</p>	<p>The factory should use Advanced Statistics to analyze data and define improvements. 工厂应使用高级的统计分析工具进行改善。</p>	2-Jan-2023

Factory Stamp & Site Representative Signature: Ms. Chen Xiaoyan

Auditor Signature: Sam Yang

Date: 03-Nov-2022

Date: 03-Nov-2022

IMPORTANT NOTES

THE ABOVE RESULT(S) REFLECT(S) QIMA LIMITED'S FINDINGS AT THE TIME AND PLACE OF AUDIT. WITH REGARD TO THE RANDOM SAMPLE CHARACTER OF THE AUDIT, IT SHOULD BE NOTED THAT ADDITIONAL NONCONFORMITIES MAY EXIST, WHICH WERE NOT FOUND DURING THE AUDIT. THE AUDITOR'S FINDINGS DO NOT RELIEVE THE AUDITEE OF ITS RESPONSIBILITY TO ENSURE THAT THE REQUIREMENTS OF THE STANDARD ARE FULFILLED AND CONSTANTLY ADHERED TO.

Factory Disclaimer

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YOUR EYES IN THE SUPPLY CHAIN

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FACTORY ACKNOWLEDGEMENT
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欢迎是Babyone - remmidemmi GmbH指定的审核机构, 将于Nov-03-2022 (审核单号R-Cloud-2223825) 根据ISO 9001 标准对你的工厂进行审核。
进行该次审核工作的审核员是Sam Yang, 19522486560

请仔细阅读且确认以下启迈的规定文件:

1/审核时的基本要求
该次审核将会是MA
任何差异将会以报告形式通知Mr. Christian Bos.

2/审核结果
审核的结果将在启迈管理部门审查后交于Babyone - remmidemmi GmbH
对以上任何条款有疑问, 请联系深圳办事处: +86 755 2223 9888

3/设备提供
我已通知审核时所需的信息和设备并会准备, 如果无法提供我将会至少提前 48 小时通知启迈

- 一台可供上网的电脑
- 任何与工厂审核相关的信息, 比如查阅质量记录、生产记录, 以及工商业营业执照及相关证书的原件。

我们的审核员在审核过程中需要对工厂的大门, 生产线, 办公室和建筑物等拍照。

4/费用
我们在此类标准工厂我们的审核员不是决定人, 且启迈会支付她一定的冲贴费用。
如果审核员向工厂索求礼物, 餐饮, 请立即与我们联系claim@qima.com, Tel: + 86 755 2223 9003. Huian Guanqun Light Industry Co., Ltd没有义务向审核员提供任何物品和金钱, 任何违规将会立即通知lient.companyName.

On behalf of (Huian Guanqun Light Industry Co., Ltd(Authorized signature only)
受益人: Huian Guanqun Light Industry Co., Ltd (授权人)

Name of Factory Representative: 工厂代表:	Audit date: 审核日期:
Signature: 签名:	Arrival Time: 到达时间: 2022.11.03 9:30
Name of Auditor: 审核员姓名:	Audit date: 审核日期:
Signature: 签名: Sam Yang	Arrival Time: 到达时间: 2022.11.3 9:30

11/03/2022 09:35

Complaint Hotline (投诉电话): China +86-755-2223-9003 /India +91 11 4672 3304
Workers Hotline: China +86-189-2655-7090 /India +91 11 4672 3304
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Original signature of the Factory Representative accepting QIMA policy including bribery issues.

Confirmation of Compliance with QIMA Code of Conduct



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Confirmation of Compliance with QIMA Code of Conduct 在审核工作结束后，将该文件打印两份并且都签上名字

带签名的中文版本 (此中文版免责声明是用于在中国地区进行的审核)

订单编号: R-Cloud-22223825 审核日期: Nov-03-2022
工厂名称: Hui'an Guanqun Light Industry Co., Ltd

我在此代表贵公司确认以下关于工厂审核期间遵守的行为准则。

1. 我确认审计人员没有接受工厂提供的任何礼物、钱或恩惠(贿赂)。	是 <input checked="" type="checkbox"/>	否,请描述具体情况
2. 我确认审计人员没有接受工厂的邀请去餐厅进餐。	是 <input checked="" type="checkbox"/>	否,请描述具体情况
3. 我确认审计人员没有接受任何除客户要求以外的金钱、礼物或样品。	是 <input checked="" type="checkbox"/>	否,请描述具体情况
4. 我确认审计人员没有向你们要任何不合理的恩惠或服务。	是 <input checked="" type="checkbox"/>	否,请描述具体情况
5. 我确认审计人员没有向工厂要求到达或离开工厂的接送服务。	是 <input checked="" type="checkbox"/>	否,请描述具体情况

本人谨以此声明以上内容均真实正确。

受益人:	工厂盖章:
工厂代表姓名:	审核日期:
签名:	离开时间: 2022.11.3 16:30
审核员姓名:	审核日期:
签名: Sa Jov	2022.11.3 16:30

如果我们的审计人员违反行为准则的,请立即联系我们,我们将安排内部审计人员尽快跟进调查处理。

11/03/2022 16:35

Complaint Hotline (投诉电话): China +86-755-2223-9003 / India +91 11 4672 3304
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Original signature of the Factory Representative confirming that auditor respected QIMA Code of Conduct.

Corrective Action Plan

Part 9
Corrective Action Plan

Client Babyone - remmidemmi GmbH QIMA Service No R-Cloud-2223825
 Supplier Huian Guanqun Light Industry Auditor(s) Sam Yang
 Co., Ltd.
 Factory Huian Guanqun Light Industry Date 03-Nov-2022
 Co., Ltd.
 Industry Textile, Apparel, Footwear & Country China
 Accessories
 Audit Type Initial

No.	Findings / Violations	Corrective action	Target completion date
2.8	No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained. 没有保留珍珠棉、气泡袋、胶骨的材料检验记录。	All records for topics affecting quality should be kept and with relevant information. 应保留所有影响质量的记录，并提供相关信息。	2-Jan-2023
3.7	"Critical" components were not identified, and there was no method to define "key" suppliers in place. "关键"组件没有被识别，也没有方法来定义"关键"供应商。	"Critical" components should be identified, and there should be method to define "key" suppliers in place. "关键"组件应该被识别，并且应该有定义"关键"供应商的方法。	2-Jan-2023
3.8	There was no system defined to ensure that any change in suppliers/materials was communicated efficiently to customer. 没有建立相应的系统来确保供应商/材料的任何变化都能有效地传达给客户。	There should be a system defined to ensure that any change in suppliers/materials was communicated efficiently to customer. 应建立相应的系统来确保供应商/材料的任何变化都能有效地传达给客户。	2-Jan-2023
3.10	There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure. 没有证据显示，需要供应商提供相应的纠正措施。	Suppliers should be requested to provide evidence of corrective actions in case of failure. 需要供应商提供相应的纠正措施。	2-Jan-2023
4.5	1. Around 10% of different color inventory fabric materials was stored together without any proper segregation. 10%左右的不同颜色的库存布料堆放在一起，没有进行隔离放置。 2. All the pearl wool in the warehouse was put on the ground. 所有的珍珠棉直接放置在地上。	Raw materials should be stored properly. 原材料应良好储存。	2-Jan-2023
4.11	1. 10% semi-finished products in cutting workshop were put against the wall. 10%左右的裁片靠墙放置。 2. Around 20% of semi-finished products in the sewing workshop were put against the	Semi-finished products should be stored properly. 半成品应良好储存。	2-Jan-2023

	wall & windows. 20%左右的车缝半成品靠墙、靠窗放置。 3. The semi-finished products in the peeling station were put on the ground directly. 削皮的半成品直接放置在地面上。		
5.2	No incoming inspection records on pearl wool/ sewing thread/ plastic bones etc. were maintained. 没有保留珍珠棉、气泡袋、胶骨的材料检验记录。	All records for topics affecting quality should be kept and with relevant information. 应保留所有影响质量的记录，并提供相关信息。	2-Jan-2023
6.4	Drinking cups were found in the production workshop. 生产车间发现水杯。	Drinking cups should be forbidden in the production workshop. 生产车间禁止使用水杯。	2-Jan-2023
8.3	Relevant qualifications for internal auditor was not available. 无法提供内审员的证书。	Relevant qualifications for internal auditor should be available. 内审员应具备相关资质。	2-Jan-2023
8.5	There were no Statistical Process Control charts existing for all critical characteristics. 没有保留关键参数的统计过程控制图表。	There should be Statistical Process Control charts existing for all critical characteristics. 应保留关键参数的统计过程控制图表。	2-Jan-2023
8.8	The factory did not provide statistical analysis records of Process Capability. 工厂没有提供工序能力统计分析记录。	The factory should provide statistical analysis records of Process Capability. 工厂应提供工序能力的统计分析记录。	2-Jan-2023
8.9	The factory did not use Advanced Statistics to analyze data and define improvements. 工厂没有使用高级的统计分析工具进行改善。	The factory should use Advanced Statistics to analyze data and define improvements. 工厂应使用高级的统计分析工具进行改善。	2-Jan-2023
8.12	There was no evidence that suppliers were requested to provide evidence of corrective actions in case of failure. 没有证据显示，需要供应商提供相应的纠正措施。	Corrective and preventive actions should be documented and recorded. 纠正和预防措施应形成文件并记录。	2-Jan-2023

Factory Stamp & Site Representative Signature:

Auditor Signature:

Date:

Date:

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Original signature of the Factory Representative agreeing with the Audit Findings and Corrective Action Plan defined.

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